

Date: Tuesday, 12/5/2006 8:13:14 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET		
Job Number	: 29766		Part Number	: D35461		
Estimate Number	: 12538		Drawing Number	: D3546 REV A		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 12/5/2006		Drawing Revision	: A		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: / /		Due Date	: 12/23/2006		
Previous Run	: 29653		Qty:	40	Um:	Each
Written By	: <i>10/06/05</i>					
Checked & Approved By	: <i>10/06/05</i>					
Comment	: Est Rev:A New Issue 06-09-27 JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S18GA	304/316 .050 Sheet 
Comment: Qty.: 0.2205 sf(s)/Unit Total : 8.8200 sf(s) 304 SS SHEET 18GA Batch: <i>m100997 10/06/11</i> (40)		
2.0	WATER JET	FLOW WATER JET 
Comment: FLOW WATER JET 1-Cut as per Dwg D3546 Dwg Rev: <i>A</i> <i>10/06/11</i> (40) Prog Rev: <i>A</i>		
2-Deburr if necessary <i>10/06/11</i> (30)		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>10/06/11</i> (40)		
4.0	QC8	SECOND CHECK <i>10/06/12</i> (60)
Comment: SECOND CHECK		
5.0	BRAKE NC	NC BRAKE 
Comment: NC BRAKE Form as per Dwg D3546 <i>SB 07/01/03</i> (40)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/01/08  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/5/2006 8:13:14 AM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 29766

Part Number: D35461

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10/01/03 (40)

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL/a.m

07/01/05 (40)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 07/01/05 (40)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5047

FL 07/01/05 (40)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

FL 07/01/08 (40)

Job Completion



FL 07/01/08

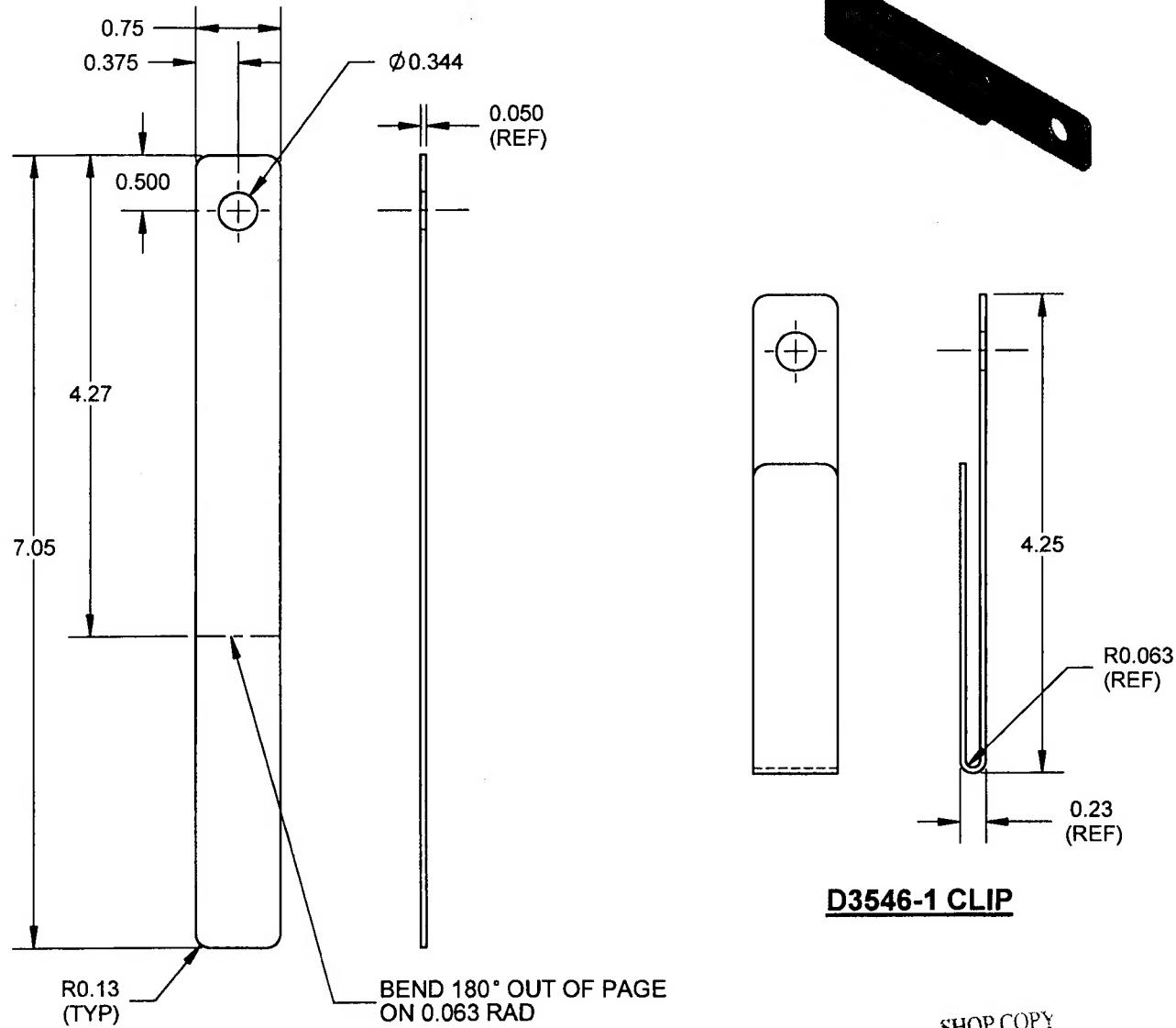
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>GP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3546	REV. A	SHEET 1 OF 1
DATE 06.09.15		TITLE CLIP	SCALE 1:1	
REV A	DATE 06.09.15	DESCRIPTION NEW ISSUE		



D3546-1 CLIP

D3546-1F FLAT PATTERN

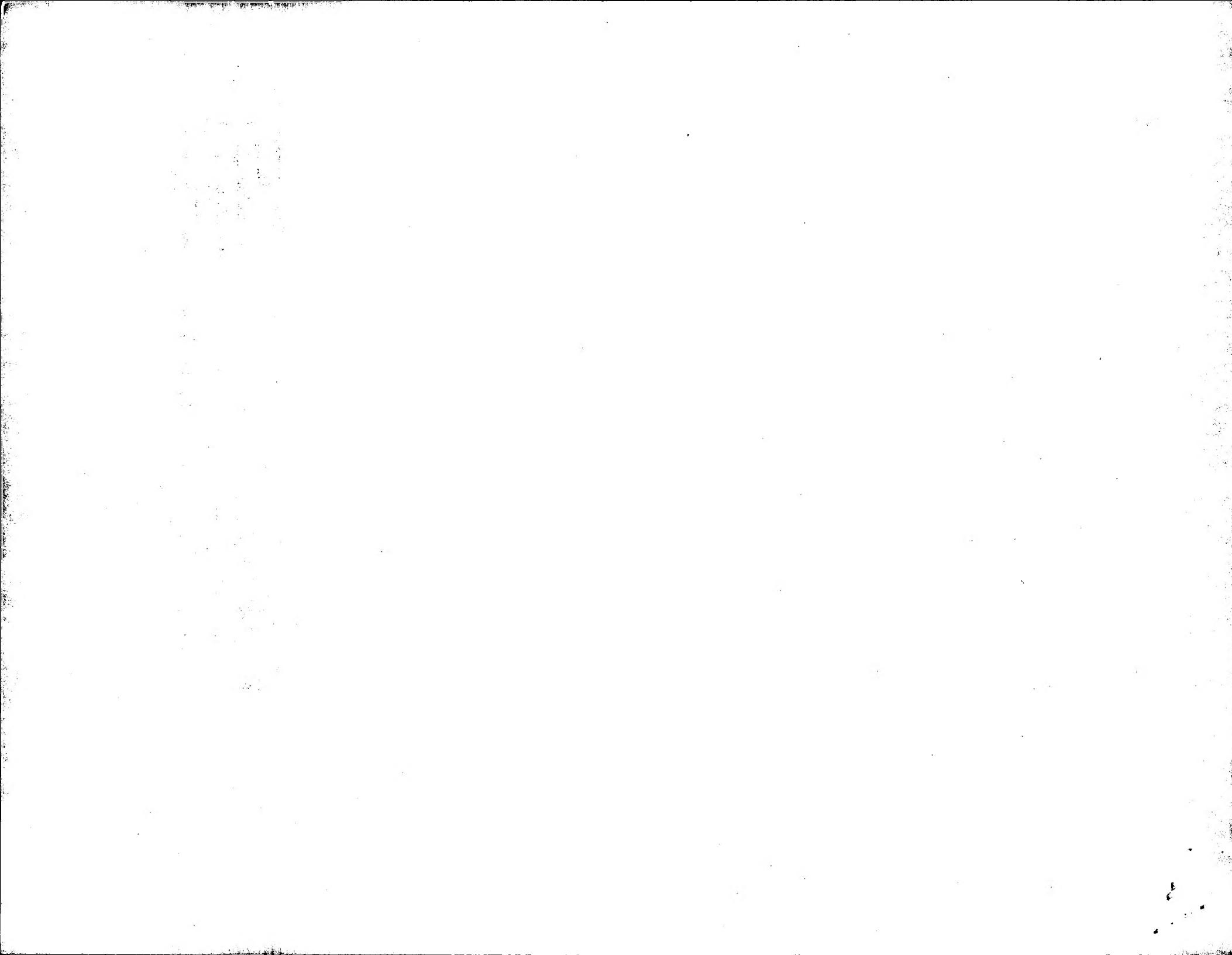
NOTES:

- 1) MATERIAL: 304/316 STAINLESS STEEL 0.050 THICK (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *29766*

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**DART AEROSPACE LTD**

**Work Order:** 29766

Description: Brachit

Part Number: D3546-1

Inspection Dwg: D3546 Rev: A

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Page 1 of 1

## ~~FIRST~~ ARTICLE INSPECTION CHECKLIST

First Article       Prototype

Measured by: *mt: ms*

**Audited by:** *[Signature]*

### Prototype Approval:

Date: 07/17/11

Date: 14-12-12

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	